



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

004951

648.4704
Job Sheet 180411



Part No: 648.4704

Job Qty: 1 ea

Part Name: C45 Overhaul



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/5/18

Job Tracking No:

Due Date: 8/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG OM & OOPM-C45 Rev 4 (648.4704) IPP Rev A 18.04.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		8/7/18	0.00	0.00	Start Up Small Fab-3		M.D.
100	Small Fab	1 pcs		8/7/18	0.00	1.00	Small Fab-3		DAS 38
120	QC	1 pcs		8/7/18	0.00	0.00	QC4		9-89
121	DC	1 pcs		8/7/18	0.00	0.00	DC		M.D.
130	Packaging	1 pcs		8/7/18	0.00	0.00	Packaging3-1		DAS 21
140	QC21-FG	1 Ea		8/7/18	0.00	0.00	QC21		21 AUG 27 2018

Part Op 100 - Pick bag and tag

Descriptions: 121 - Supply owner's & overhaul procedures manual

9-89
H.A. sold

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
NAS1149F0463P	Washer ~	3 Ea (3 ea)	90-Start up Operation	5078780
NAS1149F0563P	Washer ~	8 Ea (8 ea)	90-Start up Operation	5067901
188-FPSS-1/4-20-3/8	see P/N 188-FPSS-1/4-20-3/8 ~	2 Ea (2 ea)	100-Small Fab	5075264
188-FSCS-1032-5/8	Screw ~	4 Ea (4 ea)	100-Small Fab	5078378
600.1309-A	Label	1 Ea (1 ea)	100-Small Fab	
600.1312	Caution Sticker ~	1 Ea (1 ea)	100-Small Fab	5072105
AN4-23A	Bolt ~	2 Ea (2 ea)	100-Small Fab	F123434-40
AN5-21A	Bolt ~	4 Ea (4 ea)	100-Small Fab	5093603
C2-14-2	Label Rivets ~	2 Ea (2 ea)	100-Small Fab	5040661
C45-10-1	Spring Pin ~	1 Ea (1 ea)	100-Small Fab	5040658
C45-10-2	Lock Spring ~	1 Ea (1 ea)	100-Small Fab	5099970
C45-11-2	Locating Pin ~	2 Ea (2 ea)	100-Small Fab	5054226
C45-12-1	Lock Bushing ~	2 Ea (2 ea)	100-Small Fab	5091795
C45-12-6	Retaining Ring ~	2 Ea (2 ea)	100-Small Fab	5054986
C45-13-1	Keeper Bushing ~	2 Ea (2 ea)	100-Small Fab	5101278
C45-13-2	Spacer ~	2 Ea (2 ea)	100-Small Fab	5097746
C45-13-5	Keeper Spring ~	1 Ea (1 ea)	100-Small Fab	5029308
C45-3-1	Radial Bearing ~	2 Ea (2 ea)	100-Small Fab	5091767
C45-3-12	DU Bearing ~	1 Ea (1 ea)	100-Small Fab	5091768
C45-3-2-1	Snap Ring ~	2 Ea (2 ea)	100-Small Fab	5097898
C45-3-4-1	Retaining Ring ~	4 Ea (4 ea)	100-Small Fab	5068056
C45-3-5	Spacer ~	2 Ea (2 ea)	100-Small Fab	5097745
C45-3-8A	Actuator Shaft Bushing ~	1 Ea (1 ea)	100-Small Fab	5076197

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																										
Date : _____	Step #: _____	DART AEROSPACE Container No: S101541 Part: 648, 4704 Job No: 180411 Serial No/Batch: S101541 Revision: 4 Inspector: _____ Exp. Date: _____ Instructions: _____ Date: 08/13/18																																																										
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		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																										
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C45-3-8B	Actuator Shaft Bushing	1 Ea (1 ea)	100-Small Fab
C45-3-9	Lever Spring	1 pcs (1 ea)	100-Small Fab
C45-4-1	Trunnion Bushing	2 Ea (2 ea)	100-Small Fab
C45-5-1	Lever Stop Pin	1 Ea (1 ea)	100-Small Fab
C45-7-1P	LOADBEAM BUMPER	1 Ea (1 ea)	100-Small Fab
C45-7-2	Lock Bumper	2 Ea (2 ea)	100-Small Fab
C45-8-4	Solenoid Cover Gasket	1 Ea (1 ea)	100-Small Fab
MS21044N5	Nut	4 Ea (4 ea)	100-Small Fab
MS27039-4-08	Screw	1 Ea (1 ea)	100-Small Fab

0
5078801
5089520
~~5075347~~
5040657
5024332
5095587
5041821
5097089
509787

5078803

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	NAS1149F0463P	3	747	0
	NAS1149F0563P	8	626	0
100-Small Fab	188-FPSS-1/4 20-3/8	2	0	0
	188-FSCS-1032-5/8	4	377	0
	600.1309-A	1	0	0
	600.1312	1	22	0
	AN4-23A	2	588	0
	AN5-21A	4	73	0
	C2-14-2	2	206	0
	C45-10-1	1	91	0
	C45-10-2	1	11	0
	C45-11-2	2	78	0
	C45-12-1	2	16	0
	C45-12-6	2	84	0
	C45-13-1	2	13	0
	C45-13-2	2	82	0
	C45-13-5	1	95	0
	C45-3-1	2	18	0
	C45-3-12	1	12	0
	C45-3-2-1	2	54	0
	C45-3-4-1	4	156	0
	C45-3-5	2	78	0
	C45-3-8A	1	57	0
	C45-3-8B	1	38	0
	C45-3-9	1	0	0
	C45-4-1	2	48	0
	C45-5-1	1	41	0
	C45-7-1	1	0	0
	C45-7-2	2	12	0
	C45-8-4	1	0	0
	MS21044N5	4	139	0
	MS27039-4-08	1	78	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				